

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020151**Date Inspected:** 19-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Yu Jiao (ABF)**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** BAY 14 OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Robert A.DeArmond was present during the time noted above and conducted observations relative to the work being performed.

**OBG BAY 14**

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. All components were as listed on NWIT notification no. 08228. The member(s) is/are identified as 13BW Side Plate Sub-Ass'y and 13CE Edge Plate Sub-Ass'y. The weld designations reviewed are as follows:

SP3110-001-068~075, SP3111-001-011~016, and EP3025-001, 004, 005, 014, 015

**OBG BAY 14**

This QA Inspector observed the following work in progress:

FCAW welding of complete joint penetration weld joint(s) located on lift 14 East Line SEG-30019AG Floor Beam to Edge Plate weld number(s) 004. Welder is identified as welder no. 0066763. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-B-P-2233-ESAB.

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FCAW welding of complete joint penetration weld joint(s) located on lift 14 East Line SEG-30019AG Floor Beam to Edge Plate weld number(s) 004. Welder is identified as welder no. 0066763. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-B-P-2233-ESAB.

SMAW welding of complete joint penetration weld joint(s) located on lift 14 East Line SEG3019K Floor Beam to Bottom Plate weld number(s) 001. Welder is identified as welder no. 044772. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-345-SMAW-2G (2F)-FCM-Repair and CWR-2662.

SMAW welding of complete joint penetration weld joint(s) located on lift 14 East Line SEG3019L Floor Beam to Longitudinal Diaphragm weld number(s) 090. Welder is identified as welder no. 044772. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-B-P-2213-TC-U4b-FCM-1.

SMAW welding of complete joint penetration weld joint(s) located on lift 14 East Line SEG3019A Side Plate to Bottom Plate weld number(s) 001. Welder is identified as welder no. 066416. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-345-SMAW-1G (1F)-FCM-Repair and WR-19896.

SMAW welding of complete joint penetration weld joint(s) located on lift 14 East Line SEG3019BB Vertical Shear Plate to Bottom Plate weld number(s) 191. Welder is identified as welder no. 201087. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-345-SMAW-2G (2F)-FCM-Repair and CWR-2737.

SMAW welding of complete joint penetration weld joint(s) located on lift 14 East Line SEG3019BB Vertical Shear Plate to Bottom Plate weld number(s) 037. Welder is identified as welder no. 215553. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-345-SMAW-2G (2F)-FCM-Repair and CWR-2737.

SMAW welding of complete joint penetration weld joint(s) located on lift 14 East Line SEG3019BB Vertical Shear Plate to Bottom Plate weld number(s) 103. Welder is identified as welder no. 216086. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-345-SMAW-2G (2F)-FCM-Repair and CWR-2737.

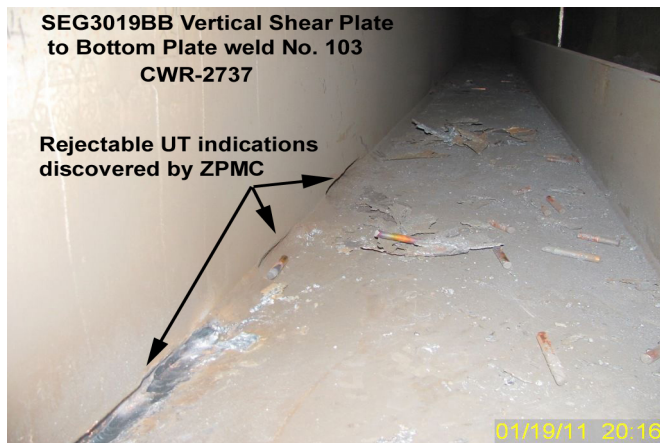
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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

As mentioned above between QA and QC concerning this project

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 1500-0042-02372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	DeArmond,Robert	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley,Ken	QA Reviewer

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